

# DRILL INSERTS & HOLDERS

钻头刀片和刀杆

## THROW-AWAY DRILL INSERTS

舍弃式钻头刀片

## DRILL INSERT HOLDERS

刀杆

## HOLDER ACCESSORIES

刀杆附品





# General Introduction

## *Throw-Away Drill Inserts and Holders*



### The Throw-Away Inserts

YG-1's throw-away drill inserts offer higher performance and excellent tool life, and are capable of drilling holes from 3/8" to 4-1/2" with nine holder groups.

All inserts are available in high-alloy High Speed Steel and Micro Grain Carbide that is manufactured powder-metallurgically.

They are offered in the latest coated grades and geometries to reduce wear and friction in higher speeds and faster feeds.

You can see cross-ground point, more positive web ground, chip breaker and sharp cutting edge for improved chip control.



### Standard Product

#### **HSS(M4) standard TiN, TiCN, TiAlN coated**

For general use in steel and cast iron.

#### **Super HSS(T15) TiN, TiCN, TiAlN coated**

For use in high nickel alloy and materials above 280Bhn hardness.

#### **Premium HSS(M48) TiN, TiCN, TiAlN coated**

For use in high temperature alloy and materials with 350-500Bhn hardness.

#### **Carbide(K10) TiN, TiCN, TiAlN coated**

For use in cast iron.

#### **Carbide(K20) TiN, TiCN, TiAlN coated**

For use in high temperature alloy, alluminum, cast iron and stainless steel.

#### **Carbide(P40) TiN, TiCN, TiAlN coated**

For general use in carbon steel and alloys steel.



# DRILL INSERT SELECTION GUIDE

SERIES Y, Z, 0		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 5
SERIES 1, 2		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 6
SERIES 3		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 7
SERIES 4		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 8
SERIES 5, 6		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 9
SERIES 7, 8		THROW-AWAY DRILL INSERTS - HSS TiAIN COATED 舍弃式钻头刀片- HSS TiAIN涂层	S 10
SERIES Y, Z, 0		THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED 舍弃式钻头刀片-硬质合金 TiAIN涂层	S 11
SERIES 1, 2		THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED 舍弃式钻头刀片-硬质合金 TiAIN涂层	S 12
SERIES 3		THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED 舍弃式钻头刀片-硬质合金 TiAIN涂层	S 13



# DRILL INSERT HOLDERS

## *Throw-Away Drill Inserts and Holders*



### Drill Insert Holders

#### **Taper Shank Holders**

<b>Metric</b> Short Length	S 26
Intermediate Length	S 26
Standard Length	S 27
Extended Length	S 28

#### **Flanged Straight Shank Holders**

<b>Metric</b> Stub Length	S 29
Short Length	S 29
Intermediate Length	S 30
Standard Length	S 30
Extended Length	S 31

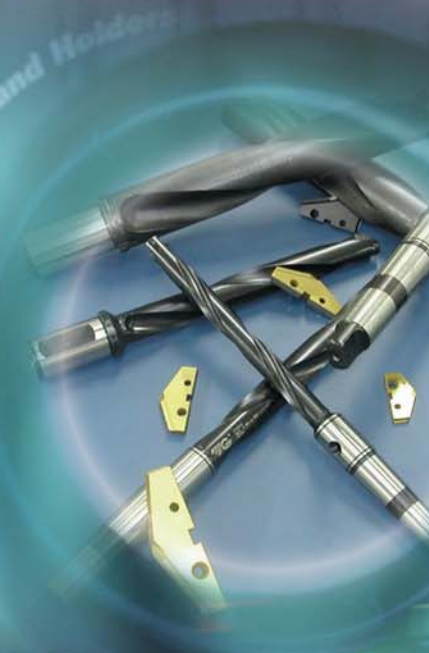
#### **Holder Accessories**

Rotary Coolant Adapter(RCA) and Accessories	S 32
Torx Screws	S 32

Throw-Away Drill Inserts and Holders

Throw-Away Drill Inserts and Holders

Throw-Away Drill Inserts and Holders





THROW-AWAY DRILL INSERTS - HSS TiAIN COATED  
 舍弃式钻头刀片- HSS TiAIN涂层



● Y, Z, O Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (mm/inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>Y</b>  9.50 (.374") to 11.07 (.436")		9.50	.3740 <sub>j</sub> ±	2.4 (3/32 <sub>j</sub> ±)	-	S1165095	S1565095
	3/8 <sub>j</sub> ±	9.53	.3750 <sub>j</sub> ±		-	S1115024	S1515024
		9.80	.3860 <sub>j</sub> ±		-	S1165098	S1565098
	25/64 <sub>j</sub> ±	9.92	.3906 <sub>j</sub> ±		-	S1115025	S1515025
		10.00	.3937 <sub>j</sub> ±		-	S1165100	S1565100
		10.20	.4016 <sub>j</sub> ±		-	S1165102	S1565102
	13/32 <sub>j</sub> ±	10.32	.4063 <sub>j</sub> ±		-	S1115026	S1515026
		10.50	.4134 <sub>j</sub> ±		-	S1165105	S1565105
	27/64 <sub>j</sub> ±	10.72	.4219 <sub>j</sub> ±		-	S1115027	S1515027
	10.80	.4252 <sub>j</sub> ±	-	S1165108	S1565108		
	11.00	.4331 <sub>j</sub> ±	-	S1165110	S1565110		
<b>Z</b>  11.11 (.437") to 12.95 (.510")	7/16 <sub>j</sub> ±	11.11	.4375 <sub>j</sub> ±	2.4 (3/32 <sub>j</sub> ±)	-	S1115028	S1515028
		11.50	.4528 <sub>j</sub> ±		-	S1165115	S1565115
	29/64 <sub>j</sub> ±	11.51	.4531 <sub>j</sub> ±		-	S1115029	S1515029
	15/32 <sub>j</sub> ±	11.91	.4688 <sub>j</sub> ±		-	S1115030	S1515030
		12.00	.4724 <sub>j</sub> ±		-	S1165120	S1565120
	31/64 <sub>j</sub> ±	12.30	.4844 <sub>j</sub> ±		-	S1115031	S1515031
		12.50	.4921 <sub>j</sub> ±		-	S1165125	S1565125
1/2 <sub>j</sub> ±	12.70	.5000 <sub>j</sub> ±	-	S1115032	S1515032		
<b>O</b>  12.98 (.511") to 17.65 (.695")		13.00	.5118 <sub>j</sub> ±	3.2 (1/8 <sub>j</sub> ±)	-	S1165130	S1565130
	33/64 <sub>j</sub> ±	13.10	.5156 <sub>j</sub> ±		-	S1115033	S1515033
	17/32 <sub>j</sub> ±	13.49	.5313 <sub>j</sub> ±		-	S1115034	S1515034
		13.50	.5315 <sub>j</sub> ±		-	S1165135	S1565135
	35/64 <sub>j</sub> ±	13.89	.5469 <sub>j</sub> ±		-	S1115035	S1515035
		14.00	.5512 <sub>j</sub> ±		-	S1165140	S1565140
	9/16 <sub>j</sub> ±	14.29	.5625 <sub>j</sub> ±		-	S1115036	S1515036
		14.50	.5709 <sub>j</sub> ±		-	S1165145	S1565145
	37/64 <sub>j</sub> ±	14.68	.5781 <sub>j</sub> ±		-	S1115037	S1515037
		15.00	.5906 <sub>j</sub> ±		-	S1165150	S1565150
	19/32 <sub>j</sub> ±	15.08	.5938 <sub>j</sub> ±		-	S1115038	S1515038
	39/64 <sub>j</sub> ±	15.48	.6094 <sub>j</sub> ±		-	S1115039	S1515039
		15.50	.6102 <sub>j</sub> ±		-	S1165155	S1565155
	5/8 <sub>j</sub> ±	15.88	.6250 <sub>j</sub> ±		-	S1115040	S1515040
		16.00	.6299 <sub>j</sub> ±		-	S1165160	S1565160
	41/64 <sub>j</sub> ±	16.27	.6406 <sub>j</sub> ±		-	S1115041	S1515041
		16.50	.6496 <sub>j</sub> ±		-	S1165165	S1565165
	21/32 <sub>j</sub> ±	16.67	.6563 <sub>j</sub> ±		-	S1115042	S1515042
		17.00	.6693 <sub>j</sub> ±		-	S1165170	S1565170
	43/64 <sub>j</sub> ±	17.07	.6719 <sub>j</sub> ±		-	S1115043	S1515043
	17.46	.6875 <sub>j</sub> ±	-	S1115044	S1515044		
11/16 <sub>j</sub> ±	17.50	.6890 <sub>j</sub> ±	-	S1165175	S1565175		



THROW-AWAY DRILL INSERTS - HSS TiAIN COATED  
 舍弃式钻头刀片- HSS TiAIN涂层



● 1, 2 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>1</b>  17.53 (.690") to 24.38 (.960")	45/64 <sub>i</sub> É	17.86	.7031 <sub>i</sub> É	<b>4.0</b> (5/32")	S1415045	S1115045	S1515045
		18.00	.7087 <sub>i</sub> É		S1465180	S1165180	S1565180
	23/32 <sub>i</sub> É	18.26	.7188 <sub>i</sub> É		S1415046	S1115046	S1515046
		18.50	.7283 <sub>i</sub> É		S1465185	S1165185	S1565185
	47/64 <sub>i</sub> É	18.65	.7344 <sub>i</sub> É		S1415047	S1115047	S1515047
		19.00	.7480 <sub>i</sub> É		S1465190	S1165190	S1565190
	3/4 <sub>i</sub> É	19.05	.7500 <sub>i</sub> É		S1415048	S1115048	S1515048
	49/64 <sub>i</sub> É	19.45	.7656 <sub>i</sub> É		S1415049	S1115049	S1515049
		19.50	.7677 <sub>i</sub> É		S1465195	S1165195	S1565195
	25/32 <sub>i</sub> É	19.84	.7813 <sub>i</sub> É		S1415050	S1115050	S1515050
		20.00	.7874 <sub>i</sub> É		S1465200	S1165200	S1565200
	51/64 <sub>i</sub> É	20.24	.7969 <sub>i</sub> É		S1415051	S1115051	S1515051
		20.50	.8071 <sub>i</sub> É		S1465205	S1165205	S1565205
	13/16 <sub>i</sub> É	20.64	.8125 <sub>i</sub> É		S1415052	S1115052	S1515052
		21.00	.8268 <sub>i</sub> É		S1465210	S1165210	S1565210
	27/32 <sub>i</sub> É	21.43	.8438 <sub>i</sub> É		S1415054	S1115054	S1515054
	55/64 <sub>i</sub> É	21.83	.8594 <sub>i</sub> É		S1415055	S1115055	S1515055
		22.00	.8661 <sub>i</sub> É		S1465220	S1165220	S1565220
	7/8 <sub>i</sub> É	22.23	.8750 <sub>i</sub> É		S1415056	S1415056	S1515056
	57/64 <sub>i</sub> É	22.62	.8906 <sub>i</sub> É		S1415057	S1415057	S1515057
	23.00	.9055 <sub>i</sub> É	S1465230	S1465230	S1565230		
29/32 <sub>i</sub> É	23.02	.9063 <sub>i</sub> É	S1415058	S1415058	S1515058		
59/64 <sub>i</sub> É	23.42	.9219 <sub>i</sub> É	S1415059	S1415059	S1515059		
15/16 <sub>i</sub> É	23.81	.9375 <sub>i</sub> É	S1415060	S1415060	S1515060		
	24.00	.9449 <sub>i</sub> É	S1465240	S1465240	S1565240		
<b>2</b>  24.41 (.961") to 35.05 (1.380")	31/32 <sub>i</sub> É	24.61	.9688 <sub>i</sub> É	<b>4.8</b> (3/16")	S1415062	S1415062	S1515062
	63/64 <sub>i</sub> É	25.00	.9843 <sub>i</sub> É		S1415063	S1415063	S1515063
	1 <sub>i</sub> É	25.40	1.0000 <sub>i</sub> É		S1415100	S1415100	S1515100
	1-1/64 <sub>i</sub> É	25.80	1.0156 <sub>i</sub> É		S1415101	S1415101	S1515101
		26.00	1.0236 <sub>i</sub> É		S1465260	S1465260	S1565260
	1-1/32 <sub>i</sub> É	26.19	1.0313 <sub>i</sub> É		S1415102	S1415102	S1515102
	1-3/64 <sub>i</sub> É	26.59	1.0469 <sub>i</sub> É		S1415103	S1415103	S1515103
	1-1/16 <sub>i</sub> É	26.99	1.0625 <sub>i</sub> É		S1415104	S1415104	S1515104
		27.00	1.0630 <sub>i</sub> É		S1465270	S1465270	S1565270
	1-3/32 <sub>i</sub> É	27.78	1.0938 <sub>i</sub> É		S1415106	S1415106	S1515106
		28.00	1.1024 <sub>i</sub> É		S1465280	S1465280	S1565280
	1-7/64 <sub>i</sub> É	28.18	1.1094 <sub>i</sub> É		S1415107	S1415107	S1515106
	1-1/8 <sub>i</sub> É	28.58	1.1250 <sub>i</sub> É		S1415108	S1415108	S1515108
		29.00	1.1417 <sub>i</sub> É		S1465290	S1465290	S1565290
	1-5/32 <sub>i</sub> É	29.37	1.1563 <sub>i</sub> É		S1415110	S1415110	S1515110
		30.00	1.1811 <sub>i</sub> É		S1465300	S1465300	S1565300
	1-3/16 <sub>i</sub> É	30.16	1.1875 <sub>i</sub> É		S1415112	S1415112	S1515112
	1-7/32 <sub>i</sub> É	30.96	1.2188 <sub>i</sub> É		S1415114	S1415114	S1515114
		31.00	1.2205 <sub>i</sub> É		S1465310	S1465310	S1565310
	1-1/4 <sub>i</sub> É	31.75	1.2500 <sub>i</sub> É		S1415116	S1415116	S1515116
		32.00	1.2598 <sub>i</sub> É		S1465320	S1465320	S1565320
	1-9/32 <sub>i</sub> É	32.54	1.2813 <sub>i</sub> É		S1415118	S1415118	S1515118
		33.00	1.2992 <sub>i</sub> É		S1465330	S1465330	S1565330
	1-5/16 <sub>i</sub> É	33.34	1.3125 <sub>i</sub> É		S1415120	S1415120	S1515120
		34.00	1.3386 <sub>i</sub> É		S1465340	S1465340	S1565340
	1-11/32 <sub>i</sub> É	34.13	1.3438 <sub>i</sub> É		S1415122	S1415122	S1515122
1-3/8 <sub>i</sub> É	34.93	1.3750 <sub>i</sub> É	S1415124	S1415124	S1515124		
	35.00	1.3780 <sub>i</sub> É	S1465350	S1465350	S1565350		



THROW-AWAY DRILL INSERTS - HSS TiAIN COATED  
 舍弃式钻头刀片- HSS TiAIN涂层



● 3 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>3</b>  34.37 (1.353") to 47.80 (1.882")	1-13/32"	35.72	1.4063"	<b>6.4</b>  (1/4")	S1415126	S1115126	-
		36.00	1.4173"		S1465360	S1165360	-
	1-7/16"	36.51	1.4375"		S1415128	S1115128	-
		37.00	1.4567"		S1465370	S1165370	-
	1-15/32"	37.31	1.4688"		S1415130	S1115130	-
		38.00	1.4961"		S1465380	S1165380	-
	1-1/2"	38.10	1.5000"		S1415132	S1115132	-
	1-17/32"	38.89	1.5313"		S1415134	S1115134	-
		39.00	1.5354"		S1465390	S1165390	-
	1-9/16"	39.69	1.5625"		S1415136	S1115136	-
		40.00	1.5748"		S1465400	S1165400	-
	1-19/32"	40.48	1.5938"		S1415138	S1115138	-
		41.00	1.6142"		S1465410	S1165410	-
	1-5/8"	41.28	1.6250"		S1415140	S1115140	-
		42.00	1.6535"		S1465420	S1165420	-
	1-21/32"	42.07	1.6563"		S1415142	S1115142	-
	1-11/16"	42.86	1.6875"		S1415144	S1115144	-
		43.00	1.6929"		S1465430	S1165430	-
	1-23/32"	43.66	1.7188"		S1415146	S1115146	-
		44.00	1.7323"		S1465440	S1165440	-
	1-3/4"	44.45	1.7500"		S1415148	S1115148	-
		45.00	1.7717"		S1465450	S1165450	-
	1-25/32"	45.24	1.7813"		S1415150	S1115150	-
		46.00	1.8110"		S1465460	S1165460	-
1-13/16"	46.04	1.8125"	S1415152	S1115152	-		
1-27/32"	46.83	1.8438"	S1415154	S1115154	-		
	47.00	1.8504"	S1465470	S1165470	-		
1-7/8"	47.63	1.8750"	S1415156	S1115156	-		



● 4 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>4</b>  46.99 (1.850") to 65.28 (2.570")		48.00	1.8898"	7.9 (5/16")	S1465480	S1165480	-
	1-29/32"	48.42	1.9063"		S1415158	S1115158	-
		49.00	1.9291"		S1465490	S1165490	-
	1-15/16"	49.21	1.9375"		S1415160	S1115160	-
		50.00	1.9685"		S1465500	S1165500	-
	1-31/32"	50.01	1.9688"		S1415162	S1115162	-
	2"	50.80	2.0000"		S1415200	S1115200	-
		51.00	2.0079"		S1465510	S1165510	-
	2-1/32"	51.59	2.0313"		S1415202	S1115202	-
	2-3/64"	52.00	2.0472"		S1415203	S1115203	-
	2-1/16"	52.39	2.0625"		S1415204	S1115204	-
		53.00	2.0866"		S1465530	S1165530	-
	2-3/32"	53.18	2.0938"		S1415206	S1115206	-
	2-1/8"	53.98	2.1250"		S1415208	S1115208	-
		54.00	2.1260"		S1465540	S1165540	-
	2-5/32"	54.79	2.1563"		S1415210	S1115210	-
		55.00	2.1654"		S1465550	S1165550	-
	2-3/16"	55.56	2.1875"		S1415212	S1115212	-
		56.00	2.2047"		S1465560	S1165560	-
	2-7/32"	56.36	2.2188"		S1415214	S1115214	-
		57.00	2.2441"		S1465570	S1165570	-
	2-1/4"	57.15	2.2500"		S1415216	S1115216	-
	2-9/32"	57.94	2.2813"		S1415218	S1115218	-
		58.00	2.2835"		S1465580	S1165580	-
	2-5/16"	58.74	2.3125"		S1415220	S1115220	-
		59.00	2.3228"		S1465590	S1165590	-
	2-11/32"	59.53	2.3438"		S1415222	S1115222	-
		60.00	2.3622"		S1465600	S1165600	-
	2-3/8"	60.33	2.3750"		S1415224	S1115224	-
		61.00	2.4016"		S1465610	S1165610	-
2-13/32"	61.12	2.4063"	S1415226	S1115226	-		
2-7/16"	61.91	2.4375"	S1415228	S1115228	-		
	62.00	2.4409"	S1465620	S1165620	-		
2-15/32"	62.71	2.4688"	S1415230	S1115230	-		
	63.00	2.4803"	S1465630	S1165630	-		
2-1/2"	63.50	2.5000"	S1415232	S1115232	-		
	64.00	2.5197"	S1465640	S1165640	-		
2-17/32"	64.29	2.5313"	S1415234	S1115234	-		
	65.00	2.5591"	S1465650	S1165650	-		
2-9/16"	65.09	2.5625"	S1415236	S1115236	-		





THROW-AWAY DRILL INSERTS - HSS TiAIN COATED  
 舍弃式钻头刀片- HSS TiAIN涂层



● 5, 6 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>5</b>  62.38 (2.456") to 76.20 (3.000")	2-1/2"	63.50	2.5000"	11.1 (7/16")	S14152D2	-	-
		64.00	2.5197"		S146564A	-	-
	2-17/32"	64.29	2.5313"		S14152D4	-	-
	2-9/16"	65.09	2.5625"		S14152D6	-	-
	2-19/32"	65.88	2.5938"		S1415238	-	-
		66.00	2.5984"		S1465660	-	-
	2-5/8"	66.68	2.6250"		S1415240	-	-
	2-21/32"	67.47	2.6563"		S1415242	-	-
		68.00	2.6772"		S1465680	-	-
	2-11/16"	68.26	2.6875"		S1415244	-	-
	2-23/32"	69.05	2.7188"		S1415246	-	-
	2-3/4"	69.85	2.7500"		S1415248	-	-
		70.00	2.7559"		S1465700	-	-
	2-25/32"	70.64	2.7813"		S1415250	-	-
	2-13/16"	71.44	2.8125"		S1415252	-	-
		72.00	2.8346"		S1465720	-	-
	2-27/32"	72.23	2.8438"		S1415254	-	-
	2-7/8"	73.03	2.8750"		S1415256	-	-
	2-29/32"	73.82	2.9063"		S1415258	-	-
		74.00	2.9134"		S1465740	-	-
2-15/16"	74.61	2.9375"	S1415260	-	-		
2-31/32"	75.41	2.9688"	S1415262	-	-		
	76.00	2.9921"	S1465760	-	-		
3"	76.20	3.0000"	S1415300	-	-		
<b>6</b>  76.23 (3.001") to 89.08 (3.507")	3-1/32"	76.99	3.0313"	11.1 (7/16")	S1415302	-	-
	3-1/16"	77.79	3.0625"		S1415304	-	-
		78.00	3.0709"		S1465780	-	-
	3-3/32"	78.58	3.0938"		S1415306	-	-
	3-1/8"	79.38	3.1250"		S1415308	-	-
		80.00	3.1496"		S1465800	-	-
	3-5/32"	80.17	3.1563"		S1415310	-	-
	3-3/16"	80.96	3.1875"		S1415312	-	-
	3-7/32"	81.76	3.2188"		S1415314	-	-
		82.00	3.2283"		S1465820	-	-
	3-1/4"	82.55	3.2500"		S1415316	-	-
	3-9/32"	83.34	3.2813"		S1415318	-	-
		84.00	3.3071"		S1465840	-	-
	3-5/16"	84.14	3.3125"		S1415320	-	-
	3-11/32"	84.93	3.3438"		S1415322	-	-
	3-3/8"	85.73	3.3750"		S1415324	-	-
		86.00	3.3858"		S1465860	-	-
	3-13/32"	86.52	3.4063"		S1415326	-	-
	3-7/16"	87.31	3.4375"		S1415328	-	-
		88.00	3.4646"		S1465880	-	-
3-15/32"	88.11	3.4688"	S1415330	-	-		
3-1/2"	88.90	3.5000"	S1415332	-	-		



THROW-AWAY DRILL INSERTS - HSS TiAIN COATED  
 舍弃式钻头刀片- HSS TiAIN涂层



● 7, 8 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	HSS Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		HSS	SUPER HSS	PREMIUM HSS
					M4	T15	M48
<b>7</b>  87.76 (3.455") to 101.60 (4.000")	3-17/32"	89.69	3.5313"	11.1 (7/16")	S1415334	-	-
		90.00	3.5433"		S1465900	-	-
	3-9/16"	90.49	3.5625"		S1415336	-	-
	3-19/32"	91.28	3.5938"		S1415338	-	-
		92.00	3.6221"		S1465920	-	-
	3-5/8"	92.08	3.6250"		S1415340	-	-
	3-21/32"	92.87	3.6563"		S1415342	-	-
	3-11/16"	93.66	3.6875"		S1415344	-	-
		94.00	3.7008"		S1465940	-	-
	3-23/32"	94.46	3.7188"		S1415346	-	-
	3-3/4"	95.25	3.7500"		S1415348	-	-
		96.00	3.7795"		S1465960	-	-
	3-25/32"	96.04	3.7813"		S1415350	-	-
	3-13/16"	96.84	3.8125"		S1415352	-	-
	3-27/32"	97.63	3.8438"		S1415354	-	-
		98.00	3.8583"		S1465980	-	-
	3-7/8"	98.43	3.8750"		S1415356	-	-
	3-29/32"	99.22	3.9063"		S1415358	-	-
		100.00	3.9370"		S1465A00	-	-
	3-15/16"	100.01	3.9375"		S1415360	-	-
3-31/32"	100.81	3.9688"	S1415362	-	-		
4"	101.60	4.0000"	S1415400	-	-		
<b>8</b>  101.63 (4.001") to 114.48 (4.507")	4-1/64"	102.00	4.0157"	11.1 (7/16")	S1415401	-	-
	4-1/16"	103.19	4.0625"		S1415404	-	-
	4-3/32"	104.00	4.0945"		S1415406	-	-
	4-1/8"	104.78	4.1250"		S1415408	-	-
		106.00	4.1732"		S1465A60	-	-
	4-3/16"	106.36	4.1875"		S1415412	-	-
	4-1/4"	107.95	4.2500"		S1415416	-	-
		108.00	4.2520"		S1465A80	-	-
	4-5/16"	109.54	4.3125"		S1415420	-	-
		110.00	4.3307"		S1465B00	-	-
	4-3/8"	111.13	4.3750"		S1415424	-	-
		112.00	4.4094"		S1465B20	-	-
	4-7/16"	112.71	4.4375"		S1415428	-	-
		114.00	4.4882"		S1465B40	-	-
	4-1/2"	114.30	4.5000"		S1415432	-	-



THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED  
 舍弃式钻头刀片-硬质合金 TiAIN涂层



● Y, Z, O Series

Series Min. to Max. (mm/inch)	Diameter			Thick	Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)	Metric (inch)	CARBIDE		
					K10	K20	P40
<b>Y</b>  9.50 (.374") to 11.07 (.436")		9.50	.3740"	<b>2.4</b> (3/32")	S1665095	S1765095	S1865095
	3/8"	9.53	.3750"		S1615024	S1715024	S1815024
		9.80	.3860"		S1665098	S1765098	S1865098
	25/64"	9.92	.3906"		S1615025	S1715025	S1815025
		10.00	.3937"		S1665100	S1765100	S1865100
		10.20	.4016"		S1665102	S1765102	S1865102
	13/32"	10.32	.4063"		S1615026	S1715026	S1815026
		10.50	.4134"		S1665105	S1765105	S1865105
	27/64"	10.72	.4219"		S1615027	S1715027	S1815027
		10.80	.4252"		S1665108	S1765108	S1865108
	11.00	.4331"	S1665110	S1765110	S1865110		
<b>Z</b>  11.11 (.437") to 12.95 (.510")	7/16"	11.11	.4375"	<b>2.4</b> (3/32")	S1615028	S1765028	S1815028
		11.50	.4528"		S1665115	S1765115	S1865115
	29/64"	11.51	.4531"		S1615029	S1715029	S1815029
	15/32"	11.91	.4688"		S1615030	S1715030	S1815030
		12.00	.4724"		S1665120	S1765120	S1865120
	31/64"	12.30	.4844"		S1615031	S1715031	S1815031
		12.50	.4921"		S1665125	S1765125	S1865125
1/2"	12.70	.5000"	S1615032	S1715032	S1815032		
<b>O</b>  12.98 (.511") to 17.65 (.695")		13.00	.5118"	<b>3.2</b> (1/8")	S1665130	S1765130	S1865130
	33/64"	13.10	.5156"		S1615033	S1715033	S1815033
	17/32"	13.49	.5313"		S1615034	S1715034	S1815034
		13.50	.5315"		S1665135	S1765135	S1865135
	35/64"	13.89	.5469"		S1615035	S1715035	S1815035
		14.00	.5512"		S1665140	S1765140	S1865140
	9/16"	14.29	.5625"		S1615036	S1715036	S1815036
		14.50	.5709"		S1665145	S1765145	S1865145
	37/64"	14.68	.5781"		S1615037	S1715037	S1815037
		15.00	.5906"		S1665150	S1765150	S1865150
	19/32"	15.08	.5938"		S1615038	S1715038	S1815038
	39/64"	15.48	.6094"		S1615039	S1715039	S1815039
		15.50	.6102"		S1665155	S1765155	S1865155
	5/8"	15.88	.6250"		S1615040	S1715040	S1815040
		16.00	.6299"		S1665160	S1765160	S1865160
	41/64"	16.27	.6406"		S1615041	S1715041	S1818041
		16.50	.6496"		S1665165	S1765165	S1865165
	21/32"	16.67	.6563"		S1615042	S1715042	S1815042
		17.00	.6693"		S1665170	S1765170	S1865170
	43/64"	17.07	.6719"		S1615043	S1715043	S1815043
11/16"	17.46	.6875"	S1615044	S1715044	S1815044		
	17.50	.6890"	S1665175	S1765175	S1865175		



# THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED

## 舍弃式钻头刀片-硬质合金 TiAIN涂层



● 1, 2 Series

Series Min. to Max. (mm/inch)	Diameter			Thick	Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)	Metric (inch)	CARBIDE		
					K10	K20	P40
<b>1</b>  17.53 (.690") to 24.38 (.960")	45/64"	17.86	.7031"	<b>4.0</b> (5/32")	S1615045	S1715045	S1815045
		18.00	.7087"		S1665180	S1765180	S1865180
	23/32"	18.26	.7188"		S1615046	S1715046	S1815046
		18.50	.7283"		S1665185	S1765185	S1865185
	47/64"	18.65	.7344"		S1615047	S1715047	S1815047
		19.00	.7480"		S1665190	S1765190	S1865190
	3/4"	19.05	.7500"		S1615048	S1715048	S1815048
	49/64"	19.45	.7656"		S1615049	S1715049	S1815049
		19.50	.7677"		S1665195	S1765195	S1865195
	25/32"	19.84	.7813"		S1615050	S1715050	S1815050
		20.00	.7874"		S1665200	S1765200	S1865200
	51/64"	20.24	.7969"		S1615051	S1715051	S1815051
		20.50	.8071"		S1665205	S1765205	S1865205
	13/16"	20.64	.8125"		S1615052	S1715052	S1815052
		21.00	.8268"		S1665210	S1765210	S1865210
	27/32"	21.43	.8438"		S1615054	S1715054	S1815054
	55/64"	21.83	.8594"		S1615055	S1715055	S1815055
		22.00	.8661"		S1665220	S1765220	S1865220
	7/8"	22.23	.8750"		S1615056	S1715056	S1815056
	57/64"	22.62	.8906"		S1615057	S1715057	S1815057
	23.00	.9055"	S1665230	S1765230	S1865230		
29/32"	23.02	.9063"	S1615058	S1715058	S1815058		
59/64"	23.42	.9219"	S1615059	S1715059	S1815059		
15/16"	23.81	.9375"	S1615060	S1715060	S1815060		
	24.00	.9449"	S1665240	S1765240	S1865240		
<b>2</b>  24.41 (.961") to 35.05 (1.380")	31/32"	24.61	.9688"	<b>4.8</b> (3/16")	S1615062	S1715062	S1815062
	63/64"	25.00	.9843"		S1615063	S1715063	S1815063
	1"	25.40	1.0000"		S1615100	S1715100	S1815100
	1-1/64"	25.80	1.0156"		S1615101	S1715101	S1815101
		26.00	1.0236"		S1665260	S1765260	S1865260
	1-1/32"	26.19	1.0313"		S1615102	S1715102	S1815102
	1-3/64"	26.59	1.0469"		S1615103	S1715103	S1815103
	1-1/16"	26.99	1.0625"		S1615104	S1715104	S1815104
		27.00	1.0630"		S1665270	S1765270	S1865270
	1-3/32"	27.78	1.0938"		S1615106	S1715106	S1815106
		28.00	1.1024"		S1665280	S1765280	S1865280
	1-7/64"	28.18	1.1094"		S1615107	S1715107	S1815107
	1-1/8"	28.58	1.1250"		S1615108	S1715108	S1815108
		29.00	1.1417"		S1665290	S1765290	S1865290
	1-5/32"	29.37	1.1563"		S1615110	S1715110	S1815110
		30.00	1.1811"		S1665300	S1765300	S1865300
	1-3/16"	30.16	1.1875"		S1615112	S1715112	S1815112
	1-7/32"	30.96	1.2188"		S1615114	S1715114	S1815114
		31.00	1.2205"		S1665310	S1765310	S1865310
	1-1/4"	31.75	1.2500"		S1615116	S1715116	S1815116
		32.00	1.2598"		S1665320	S1765320	S1865320
	1-9/32"	32.54	1.2813"		S1615118	S1715118	S1815118
		33.00	1.2992"		S1665330	S1765330	S1865330
	1-5/16"	33.34	1.3125"		S1615120	S1715120	S1815120
		34.00	1.3386"		S1665340	S1765340	S1865340
	1-11/32"	34.13	1.3438"		S1615122	S1715122	S1815122
1-3/8"	34.93	1.3750"	S1615124	S1715124	S1815124		
	35.00	1.3780"	S1665350	S1765350	S1865350		



THROW-AWAY DRILL INSERTS - CARBIDE TiAIN COATED  
 舍弃式钻头刀片-硬质合金 TiAIN涂层



● 3 Series

Series Min. to Max. (mm/inch)	Diameter			Thick  Metric (inch)	Spade Drill Inserts TiAIN Coating EDP No.		
	Inch (inch)	Metric (mm)	Decimal (inch)		CARBIDE		
					K10	K20	P40
<b>3</b>  34.37 (1.353") to 47.80 (1.882")	1-13/32"	35.72	1.4063"	<b>6.4</b> (1/4")		S1715126	S1815126
		36.00	1.4173"			S1765360	S1865360
	1-7/16"	36.51	1.4375"			S1715128	S1815128
		37.00	1.4567"			S1765370	S1865370
	1-15/32"	37.31	1.4688"			S1715130	S1815130
		38.00	1.4961"			S1765380	S1865380
	1-1/2"	38.10	1.5000"			S1715132	S1815132
	1-17/32"	38.89	1.5313"			S1715134	S1815134
		39.00	1.5354"			S1765390	S1865390
	1-9/16"	39.69	1.5625"			S1715136	S1815136
		40.00	1.5748"			S1765400	S1865400
	1-19/32"	40.48	1.5938"			S1715138	S1815138
		41.00	1.6142"			S1765410	S1865410
	1-5/8"	41.28	1.6250"			S1715140	S1815140
		42.00	1.6535"			S1765420	S1865420
	1-21/32"	42.07	1.6563"			S1715142	S1815142
	1-11/16"	42.86	1.6875"			S1715144	S1815144
		43.00	1.6929"			S1765430	S1865430
	1-23/32"	43.66	1.7188"			S1715146	S1815146
		44.00	1.7323"			S1765440	S1865440
	1-3/4"	44.45	1.7500"			S1715148	S1815148
		45.00	1.7717"			S1765450	S1865450
	1-25/32"	45.24	1.7813"			S1715150	S1815150
		46.00	1.8110"			S1765460	S1865460
1-13/16"	46.04	1.8125"		S1715152	S1815152		
1-27/32"	46.83	1.8438"		S1715154	S1815154		
	47.00	1.8504"		S1765470	S1865470		
1-7/8"	47.63	1.8750"		S1715156	S1815156		





## RECOMMENDED CUTTING CONDITIONS DRILL INSERTS (METRIC) - HSS

Material	Material Hardness (Bhn)	* HSS Grade	Speed (M/min)			Feed (mm / rev)						
			TiN	TiCN	TiAlN	φ 9.5 ~12.5	φ 13 ~17.5	φ 18 ~24	φ 25 ~35	φ 36 ~47	φ 48 ~65	φ 66 ~114
<b>Free machining Steel</b> 1213, 12L13, 1215 12L14, 1118 etc	100 - 150	HSS	63	79	84	0.16	0.23	0.31	0.40	0.48	0.55	0.67
	150 - 200	HSS	58	70	81	0.16	0.23	0.31	0.40	0.48	0.55	0.67
	200 - 250	HSS	51	66	72	0.14	0.23	0.31	0.38	0.48	0.57	0.69
<b>Low Carbon Steel</b> 1015, 1020, 1140 1025 etc	85 - 125	HSS	54	67	75	0.15	0.22	0.28	0.37	0.46	0.56	0.67
	125 - 175	HSS	51	63	72	0.15	0.22	0.28	0.37	0.46	0.56	0.67
	175 - 225	HSS	49	58	69	0.13	0.19	0.24	0.34	0.43	0.50	0.57
	225 - 275	HSS	45	56	66	0.13	0.19	0.24	0.34	0.43	0.50	0.57
<b>Medium Carbon Steel</b> 1035, 1050, 1045 1055, 1140 etc	125 - 175	HSS	52	63	75	0.14	0.22	0.28	0.35	0.45	0.55	0.65
	175 - 225	HSS	48	59	69	0.13	0.19	0.23	0.34	0.43	0.50	0.58
	225 - 275	HSS	45	56	63	0.13	0.19	0.23	0.34	0.43	0.50	0.58
	275 - 325	SH, PH	42	52	58	0.10	0.17	0.21	0.28	0.38	0.45	0.55
<b>Structural Steel</b> A36, A516, A182 etc	100 - 150	HSS	44	56	63	0.14	0.23	0.29	0.35	0.44	0.50	0.63
	150 - 250	HSS	39	47	55	0.13	0.22	0.24	0.28	0.38	0.46	0.59
	250 - 350	SH, PH	32	41	41	0.10	0.20	0.22	0.24	0.34	0.40	0.48
<b>Cast Iron / S,G Iron</b> A48-76 GR30/GR45 A536-72 60-40-18 A220-76 GR40010 etc	120 - 150	HSS	52	64	75	0.16	0.30	0.40	0.49	0.59	0.69	0.75
	150 - 200	HSS	48	58	70	0.14	0.26	0.35	0.45	0.56	0.64	0.68
	200 - 220	HSS	42	53	58	0.14	0.23	0.30	0.41	0.46	0.52	0.60
	220 - 260	SH, PH	35	44	52	0.13	0.17	0.23	0.30	0.35	0.43	0.50
	260 - 320	SH, PH	29	35	41	0.10	0.15	0.16	0.23	0.28	0.35	0.40
<b>Alloy Steel</b> 8620, 4130, 4137 4140, 6150 etc	125 - 175	HSS	48	58	63	0.15	0.20	0.24	0.36	0.43	0.47	0.53
	175 - 225	HSS	45	56	58	0.13	0.20	0.24	0.36	0.42	0.46	0.55
	225 - 275	HSS	41	50	56	0.13	0.16	0.23	0.35	0.41	0.44	0.55
	275 - 325	SH, PH	39	47	53	0.09	0.15	0.22	0.28	0.38	0.41	0.50
	325 - 375	SH, PH	36	43	46	0.08	0.15	0.21	0.27	0.38	0.40	0.51
<b>Tool Steel</b> H13, H21, A2, S1 etc	150 - 200	SH	25	34	34	0.09	0.15	0.19	0.25	0.28	0.36	0.41
	200 - 250	SH, PH	19	27	26	0.09	0.15	0.19	0.25	0.28	0.36	0.41
<b>High Temp. Alloy</b> Hastelloy B, Inconel etc	140 - 220	SH, PH	11	11	12	0.08	0.17	0.20	0.24	0.30	0.37	-
	220 - 310	PH	10	9	11	0.08	0.14	0.18	0.19	0.25	0.29	-
<b>High Strength Alloy</b> 9840, 4340, 4330V etc	225 - 300	SH, PH	25	34	35	0.13	0.18	0.23	0.24	0.36	0.43	0.50
	300 - 350	SH, PH	19	26	27	0.10	0.18	0.23	0.24	0.36	0.43	0.50
	350 - 400	PH	16	21	21	0.08	0.15	0.20	0.22	0.30	0.48	0.46
<b>Aluminium</b> 2014, 6061, 7075 etc	30	HSS	187	229	244	0.19	0.33	0.41	0.50	0.54	0.64	0.62
	180	HSS	92	137	137	0.19	0.33	0.41	0.46	0.54	0.64	0.62
<b>Stainless Steel</b> 310, 316, 410, 330 etc	135 - 185	HSS	24	29	34	0.14	0.20	0.23	0.26	0.36	0.41	0.50
	185 - 275	HSS	20	23	29	0.12	0.18	0.20	0.24	0.30	0.36	0.46

**RPM** = revolution per minute (rev/min)

**M/min** = surface meter per minute(M/min)

**DIA** = diameter of drill (mm)

**mm/rev** = feed rate(mm/rev)

**※ Formulas :**

$$\text{M/min} = \frac{(\text{RPM}) \cdot (\pi) \cdot (\text{DIA.})}{1000}$$

$$\text{mm/min} = (\text{RPM}) \cdot (\text{mm/rev})$$

$$\text{RPM} = \frac{(\text{M/min}) \cdot (1000)}{(\pi) \cdot (\text{DIA.})}$$

\* **HSS Grade** : **HSS** = HSS M4, **SH** = Super HSS T15, **PH** = Premium HSS M48

The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.



## RECOMMENDED CUTTING CONDITIONS DRILL INSERTS (METRIC) - CARBIDE

Material	Material Hardness (Bhn)	CARBIDE Grade	Speed (M/min)			Feed (mm / rev)				
			TiN	TiCN	TiAlN	φ 9.5 ~12.5	φ 13 ~17.5	φ 18 ~24	φ 25 ~35	φ 36 ~47
<b>Free machining Steel</b> 12L13, 12L13, 1215 12L14, 1118 etc	100 - 150	P40	101	113	125	0.13	0.21	0.29	0.36	0.47
	150 - 200	P40	88	99	110	0.13	0.19	0.27	0.31	0.42
	200 - 250	P40	82	88	101	0.12	0.18	0.24	0.29	0.38
<b>Low Carbon Steel</b> 1015, 1020, 1140 1025 etc	85 - 125	P40	94	110	119	0.15	0.19	0.25	0.35	0.45
	125 - 175	P40	82	88	107	0.13	0.19	0.24	0.34	0.44
	175 - 225	P40	76	82	96	0.10	0.17	0.20	0.30	0.41
	225 - 275	P40	62	73	84	0.10	0.17	0.19	0.29	0.37
<b>Medium Carbon Steel</b> 1035, 1050, 1045 1055, 1140 etc	125 - 175	P40	82	88	102	0.12	0.19	0.24	0.34	0.42
	175 - 225	P40	75	84	93	0.11	0.17	0.20	0.30	0.40
	225 - 275	P40	66	70	84	0.10	0.17	0.19	0.29	0.38
	275 - 325	P40	56	64	67	0.10	0.14	0.16	0.25	0.35
<b>Structural Steel</b> A36, A516, A182 etc	100 - 150	P40	75	82	91	0.14	0.23	0.27	0.29	0.40
	150 - 250	P40	62	70	75	0.13	0.19	0.24	0.26	0.38
	250 - 350	P40	55	64	73	0.10	0.17	0.20	0.22	0.32
<b>Cast Iron / S,G Iron</b> A48-76 GR30/GR45 A536-72 60-40-18 A220-76 GR40010 etc	120 - 150	K20,K10	98	125	137	0.13	0.22	0.27	0.37	0.48
	150 - 200	K20,K10	95	101	125	0.12	0.20	0.25	0.35	0.46
	200 - 220	K20,K10	75	91	111	0.12	0.18	0.20	0.31	0.35
	220 - 260	K20,K10	66	81	93	0.10	0.15	0.17	0.24	0.33
	260 - 320	K20,K10	56	70	79	0.10	0.14	0.14	0.20	0.27
<b>Alloy Steel</b> 8620, 4130, 4137 4140, 6150 etc	125 - 175	P40	79	85	98	0.13	0.20	0.24	0.31	0.39
	175 - 225	P40	73	81	88	0.13	0.19	0.22	0.30	0.37
	225 - 275	P40	66	73	81	0.10	0.18	0.21	0.29	0.36
	275 - 325	P40	62	70	78	0.09	0.15	0.20	0.28	0.35
	325 - 375	P40	53	58	64	0.08	0.13	0.19	0.24	0.33
<b>Tool Steel</b> H13, H21, A2, S1 etc	150 - 200	P40	50	56	67	0.07	0.12	0.17	0.22	0.27
	200 - 250	P40	37	46	50	0.07	0.12	0.16	0.21	0.26
<b>High Temp. Alloy</b> Hastelloy B, Inconel etc	140 - 220	K20	26	27	30	0.08	0.32	0.17	0.22	0.26
	220 - 310	K20	20	23	24	0.08	0.28	0.15	0.19	0.23
<b>High Strength Alloy</b> 9840, 4340, 4330V etc	225 - 300	P40	49	55	62	0.13	0.18	0.19	0.23	0.34
	300 - 350	P40	43	49	55	0.10	0.15	0.18	0.22	0.30
	350 - 400	P40	38	43	47	0.08	0.13	0.15	0.19	0.24
<b>Aluminium</b> 2014, 6061, 7075 etc	30	K20	366	396	427	0.19	0.32	0.40	0.47	0.52
	180	K20	244	290	291	0.17	0.27	0.34	0.45	0.49
<b>Stainless Steel</b> 310, 316, 410, 330 etc	135 - 185	K20	50	55	62	0.14	0.20	0.22	0.26	0.32
	185 - 275	K20	38	44	46	0.12	0.18	0.19	0.24	0.28

**RPM** = revolution per minute (rev/min)

**M/min** = surface meter per minute(M/min)

**DIA** = diameter of drill (mm)

**mm/rev** = feed rate(mm/rev)

※ **Formulas :**

$$M/min = \frac{(RPM) \cdot (\pi) \cdot (DIA.)}{1000}$$

$$mm/min = (RPM) \cdot (mm/rev)$$

$$RPM = \frac{(M/min) \cdot (1000)}{(\pi) \cdot (DIA.)}$$

The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.





DESIGNATION SYSTEM  
DRILL INSERT ITEM : Metric



**Drill Insert**

**Form**

- 1. Throw-Away
- 2. Throw-Away Flat Bottom
- R. Throw-Away SR-Point

**Material**

- |        |        |        |
|--------|--------|--------|
| 1: T15 | 4: M4  | 7: K20 |
| 2:     | 5: M48 | 8: P40 |
| 3:     | 6: K10 |        |

**Unit & Surface Treatment**

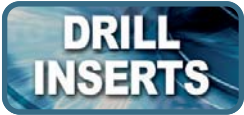
- |                      |                           |
|----------------------|---------------------------|
| 55: Inch+TiN Coated  | 65: Inch+TiAlN Coated     |
| 60: Inch+TiCN Coated | 70: Inch+Hardslick Coated |

**SIZE1 - Diameter : Positive Number Portion**

- |            |            |             |             |             |
|------------|------------|-------------|-------------|-------------|
| 09.50 : 09 | 25.40 : 25 | 100.00 : A0 | 111.14 : B1 | 125.50 : C5 |
| 12.70 : 12 | 50.50 : 50 | 101.20 : A1 | 115.40 : B5 | 128.60 : C8 |

**SIZE2 - Diameter : Decimal Portion**

- |           |           |            |            |            |
|-----------|-----------|------------|------------|------------|
| 9.50 : 5  | 25.40 : 4 | 100.00 : 0 | 111.14 : 1 | 125.50 : 5 |
| 12.70 : 7 | 50.50 : 5 | 101.20 : 2 | 115.40 : 4 | 128.60 : 6 |



DESIGNATION SYSTEM  
DRILL INSERT ITEM : INCH



**Drill Insert**

**Form**

- 1. Throw-Away
- 2. Throw-Away Flat Bottom
- R. Throw-Away SR-Point

**Material**

- |        |        |        |
|--------|--------|--------|
| 1: T15 | 4: M4  | 7: K20 |
| 2:     | 5: M48 | 8: P40 |
| 3:     | 6: K10 |        |

**Unit & Surface Treatment**

- |                      |                           |
|----------------------|---------------------------|
| 05: Inch+TiN Coated  | 15: Inch+TiAlN Coated     |
| 10: Inch+TiCN Coated | 20: Inch+Hardslick Coated |

**SIZE1 - Diameter : Positive Number Portion**

- |           |            |            |             |
|-----------|------------|------------|-------------|
| 1*1/4 : 1 | 3*5/16 : 3 | 10*1/2 : A | 12*3/8 : C  |
| 2*3/8 : 2 | 4*1/2 : 4  | 11*1/4 : B | 13*5/16 : D |

**SIZE2 - Diameter : Decimal Portion by 1/64**

- |            |            |            |
|------------|------------|------------|
| 1/4 : 16   | 3/8 : 24   | 1/2 : 32   |
| 5/8 : 40   | 3/4 : 48   | 7/8 : 56   |
| 5/16 : 20  | 7/16 : 28  | 9/16 : 36  |
| 11/16 : 44 | 13/16 : 52 | 15/16 : 60 |



# Drill Insert Holders

## SELECTION GUIDE

### *Throw-Away Drill Inserts and Holders*

*Taper Shank Holders*

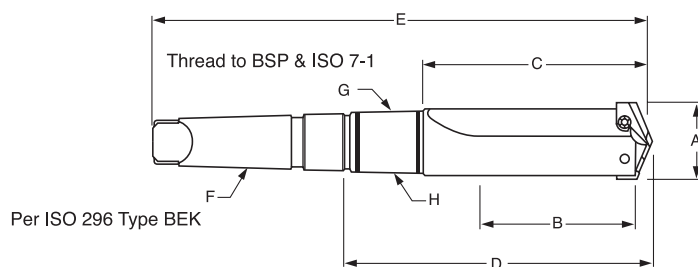
*Flanged Straight Shank Holders*

*Holder Accessories*



**DRILL HOLDERS**

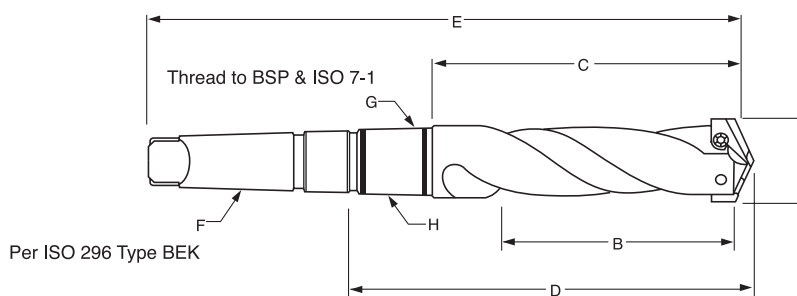
TAPER SHANK HOLDERS SHORT LENGTH - STRAIGHT FLUTE (METRIC)  
短锥柄刀杆-直刃



Series	EDP No.	A	B	C	D	E	F	G	H
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCA
Y	P51Y0020	9.5 ~ 11.0	31.8	51.5	88.0	160.3	#2	1/16"	PR120190
Z	P51Z0020	11.5 ~ 12.5	31.8	51.5	88.0	160.3	#2	1/16"	PR120190
0	P5100020	13.0 ~ 17.5	35.0	55.5	92.4	164.3	#2	1/16"	PR120190
0.5	P5105020	15.5 ~ 17.5	35.0	55.5	92.4	164.3	#2	1/16"	PR120190
1	P5110030	18.0 ~ 24.0	69.8	98.4	142.5	232.5	#3	1/8"	PR120254
1.5	P5115030	22.0 ~ 24.0	69.8	98.4	142.5	232.5	#3	1/8"	PR120254
2	P5120040	25.0 ~ 35.0	85.7	114.3	160.4	273.8	#4	1/8"	PR120254
2.5	P5125040	30.0 ~ 35.0	85.7	114.3	167.6	281.0	#4	1/4"	PR120317
3	P5130040	36.0 ~ 47.0	120.6	152.4	206.4	319.1	#4	1/4"	PR120317
4	P5140050	48.0 ~ 65.0	130.1	165.1	219.1	363.5	#5	1/4"	PR120444
5	P5150050	64.0 ~ 88.0	171.5	215.9	287.3	430.2	#5	1/2"	PR120571
7	P5170050	90.0 ~ 114.0	171.5	225.4	296.8	439.7	#5	1/2"	PR120571

**DRILL HOLDERS**

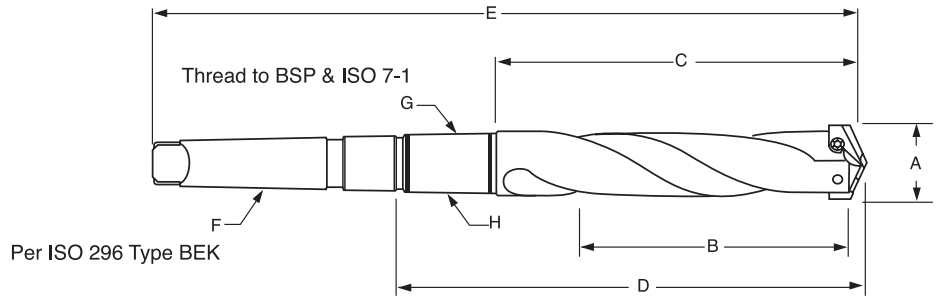
TAPER SHANK HOLDERS INTERMEDIATE LENGTH - SPIRAL FLUTE (METRIC)  
普长锥柄刀杆-螺旋刃



Series	EDP No.	A	B	C	D	E	F	G	H
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCA
1	P5810030	18.0 ~ 24.0	120.7	149.2	193.3	283.3	#3	1/8"	PR120254
1.5	P5815030	22.0 ~ 24.0	120.7	149.2	193.3	283.3	#3	1/8"	PR120254
2	P5820040	25.0 ~ 35.0	136.5	165.1	211.2	324.6	#4	1/8"	PR120254
2.5	P5825040	30.0 ~ 35.0	136.5	165.1	218.4	331.8	#4	1/4"	PR120317
3	P5830040	36.0 ~ 47.0	165.1	196.9	250.9	363.6	#4	1/4"	PR120317

**DRILL  
HOLDERS**

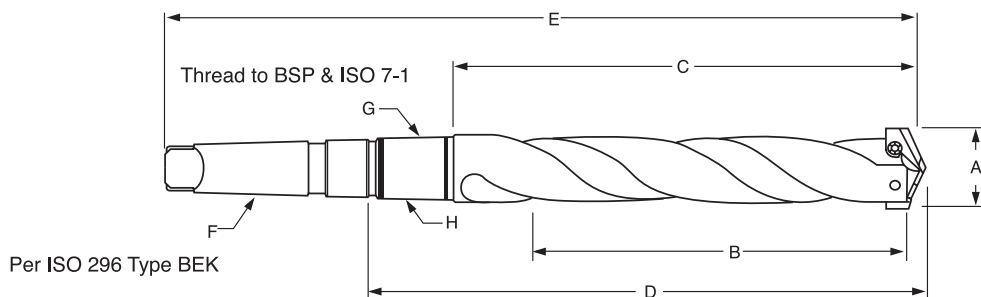
TAPER SHANK HOLDERS STANDARD LENGTH - SPIRAL FLUTE (METRIC)  
标长锥柄刀杆-螺旋刃



Series	EDP No.	A	B	C	D	E	F	G	H
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCA
Y	P59Y0020	9.5 ~ 11.0	60.3	80.2	116.7	188.9	#2	1/16"	PR120190
Z	P59Z0020	11.5 ~ 12.5	60.3	80.2	116.7	188.9	#2	1/16"	PR120190
0	P5900020	13.0 ~ 17.5	63.5	84.1	121.0	192.9	#2	1/16"	PR120190
0.5	P5905020	15.5 ~ 17.5	63.5	84.1	121.0	192.9	#2	1/16"	PR120190
1	P5910030	18.0 ~ 24.0	171.5	200.0	244.1	334.2	#3	1/8"	PR120254
1.5	P5915030	22.0 ~ 24.0	171.5	200.0	244.1	334.2	#3	1/8"	PR120254
2	P5920040	25.0 ~ 35.0	187.3	215.9	262.0	375.4	#4	1/8"	PR120254
2.5	P5925040	30.0 ~ 35.0	187.3	215.9	269.2	382.6	#4	1/4"	PR120317
3	P5930040	36.0 ~ 47.0	209.5	241.3	295.3	408.0	#4	1/4"	PR120317
4	P5940050	48.0 ~ 65.0	231.8	266.7	320.7	465.1	#5	1/4"	PR120444
5	P5950050	64.0 ~ 88.0	273.1	317.5	388.9	531.8	#5	1/2"	PR120571
7	P5970050	90.0 ~ 114.0	273.1	327.0	398.5	541.3	#5	1/2"	PR120571

**DRILL HOLDERS**

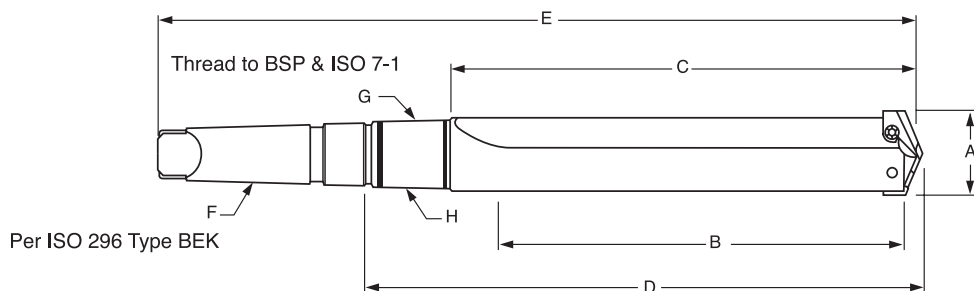
TAPER SHANK HOLDERS EXTENDED LENGTH - SPIRAL FLUTE (METRIC)  
 加长锥柄刀杆-螺旋刃



Series	EDP No.	A	B	C	D	E	F	G	H
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCA
Y	P60Y0020	9.5 ~ 11.0	111.1	130.9	167.4	239.7	#2	1/16"	PR120190
Z	P60Z0020	11.5 ~ 12.5	111.1	130.9	167.4	239.7	#2	1/16"	PR120190
0	P6000020	13.0 ~ 17.5	114.3	135.0	171.8	243.7	#2	1/16"	PR120190
0.5	P6005020	15.5 ~ 17.5	114.3	135.0	171.8	243.7	#2	1/16"	PR120190
1	P6010030	18.0 ~ 24.0	273.1	301.6	345.7	435.8	#3	1/8"	PR120254
1.5	P6015030	22.0 ~ 24.0	273.1	301.6	345.7	435.8	#3	1/8"	PR120254
2	P6020040	25.0 ~ 35.0	289.0	317.5	363.6	477.0	#4	1/8"	PR120254
2.5	P6025040	30.0 ~ 35.0	289.0	317.5	370.8	484.2	#4	1/4"	PR120317

**DRILL HOLDERS**

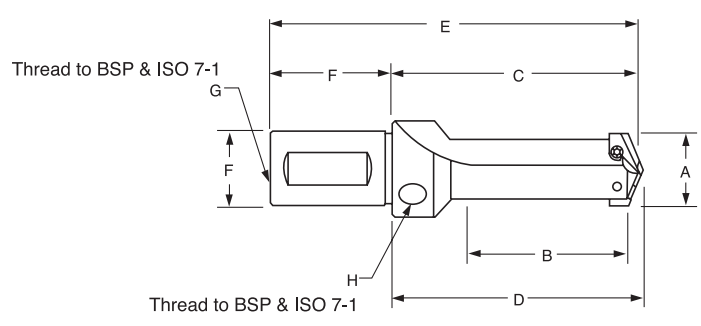
TAPER SHANK HOLDERS EXTENDED LENGTH - STRAIGHT FLUTE (METRIC)  
 加长锥柄刀杆-直刃



Series	EDP No.	A	B	C	D	E	F	G	H
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCA
3	P5430040	36.0 ~ 47.0	349.3	381.0	435.0	547.7	#4	1/4"	PR120317
4	P5440050	48.0 ~ 65.0	422.3	457.2	511.2	655.6	#5	1/4"	PR120444
5	P5450050	64.0 ~ 88.0	463.6	508.0	579.4	722.3	#5	1/2"	PR120571
7	P5470050	90.0 ~ 114.0	555.6	609.6	681.1	823.9	#5	1/2"	PR120571

## DRILL HOLDERS

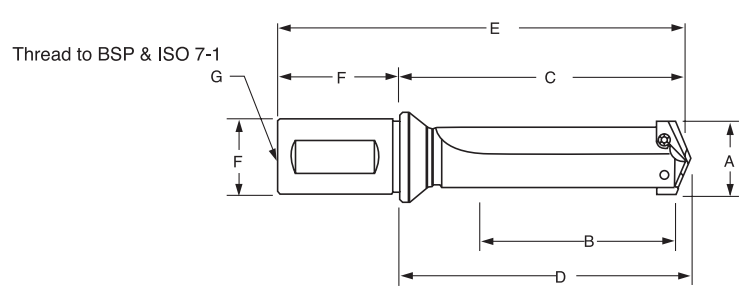
### FLANGED STRAIGHT SHANK HOLDERS STUB LENGTH - STRAIGHT FLUTE (METRIC) 超短凸缘直柄刀杆-直刃



Series	EDP No.	A	B	C	D	E	F		G	
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Dia.	Length	Rear	Side
Y	P74Y0160	9.5 ~ 11.0	19.1	47.6	50.0	89.5	16.0	41.9	1/16"	1/8"
Z	P74Z0160	11.5 ~ 12.5	19.1	47.6	50.0	89.5	16.0	41.9	1/16"	1/8"
0	P7400200	13.0 ~ 17.5	22.2	47.6	50.4	89.5	20.0	41.9	1/8"	1/8"
0.5	P7405200	15.5 ~ 17.5	22.2	47.6	50.4	89.5	20.0	41.9	1/8"	1/8"
1	P7410250	18.0 ~ 24.0	47.6	75.8	79.4	128.9	25.0	53.1	1/8"	1/8"
1.5	P7415250	22.0 ~ 24.0	57.2	88.5	92.1	141.6	25.0	53.1	1/8"	1/8"
2	P7420320	25.0 ~ 35.0	57.2	88.5	92.1	146.4	32.0	57.9	1/4"	1/8"

## DRILL HOLDERS

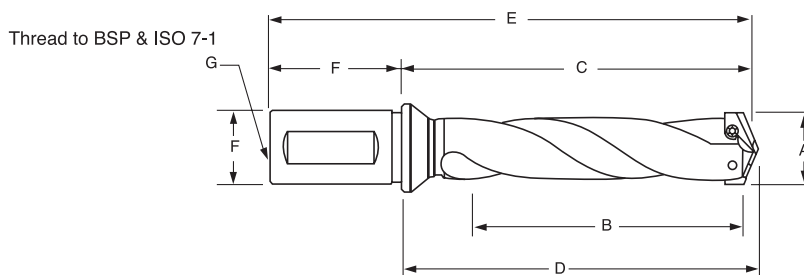
### FLANGED STRAIGHT SHANK HOLDERS SHORT LENGTH - STRAIGHT FLUTE (METRIC) 短凸缘直柄刀杆-直刃



Series	EDP No.	A	B	C	D	E	F		G
		Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Dia.	Length	Pipe Tap
Y	P75Y0200	9.5 ~ 11.0	31.8	61.1	63.5	103.0	20.0	41.9	1/8"
Z	P75Z0200	11.5 ~ 12.5	31.8	61.1	63.5	103.0	20.0	41.9	1/8"
0	P7500200	13.0 ~ 17.5	34.9	63.5	66.3	105.4	20.0	41.9	1/8"
0.5	P7505200	15.5 ~ 17.5	34.9	63.5	66.3	105.4	20.0	41.9	1/8"
1	P7510250	18.0 ~ 24.0	66.7	107.2	110.7	160.2	25.0	53.1	1/8"
1.5	P7515250	22.0 ~ 24.0	66.7	107.2	110.7	160.2	25.0	53.1	1/8"
2	P7520320	25.0 ~ 35.0	85.7	128.6	132.2	186.5	32.0	57.9	1/4"
2.5	P7525320	30.0 ~ 35.0	85.7	128.6	132.2	186.5	32.0	57.9	1/4"
3	P7530400	36.0 ~ 47.0	120.7	173.0	177.8	243.1	40.0	70.1	1/4"
4	P7540400	48.0 ~ 65.0	130.2	179.4	184.2	249.5	40.0	70.1	1/4"

**DRILL HOLDERS**

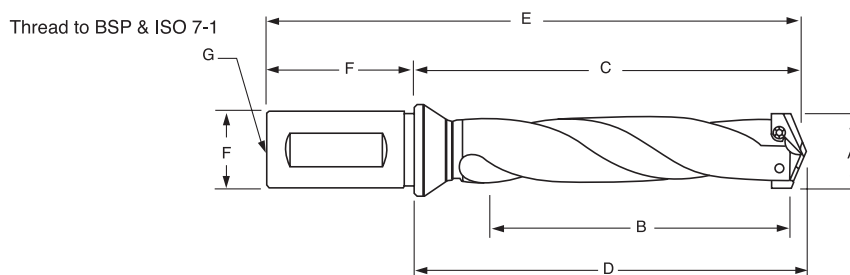
FLANGED STRAIGHT SHANK HOLDERS INTERMEDIATE LENGTH - SPIRAL FLUTE (METRIC)  
普长凸缘直柄刀杆-螺旋刃



Series	EDP No.	A Drill Insert Range	B Max. Drill Depth	C Flute Length	D Ref. Length	E Overall Length	F Shank		G Pipe Tap
							Dia.	Length	
1	P8210250	18.0 ~ 24.0	117.5	154.8	158.4	207.9	25.0	53.1	1/8"
1.5	P8215250	22.0 ~ 24.0	117.5	154.8	158.4	207.9	25.0	53.1	1/8"
2	P8220320	25.0 ~ 35.0	136.5	179.4	183.0	237.3	32.0	57.9	1/4"
2.5	P8225320	30.0 ~ 35.0	136.5	179.4	183.0	237.3	32.0	57.9	1/4"
3	P8230400	36.0 ~ 47.0	165.1	217.5	222.3	287.6	40.0	70.1	1/4"

**DRILL HOLDERS**

FLANGED STRAIGHT SHANK HOLDERS STANDARD LENGTH - SPIRAL FLUTE (METRIC)  
标长凸缘直柄刀杆-螺旋刃

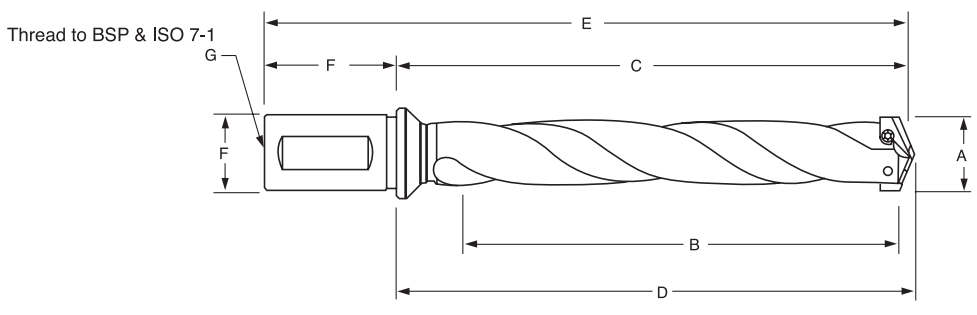


Series	EDP No.	A Drill Insert Range	B Max. Drill Depth	C Flute Length	D Ref. Length	E Overall Length	F Shank		G Pipe Tap
							Dia.	Length	
Y	P83Y0200	9.5 ~ 11.0	60.3	89.7	92.1	131.6	20.0	41.9	1/8"
Z	P83Z0200	11.5 ~ 12.5	60.3	89.7	92.1	131.6	20.0	41.9	1/8"
0	P8300200	13.0 ~ 17.5	63.5	92.1	94.9	134.0	20.0	41.9	1/8"
0.5	P8305200	15.5 ~ 17.5	63.5	92.1	94.9	134.0	20.0	41.9	1/8"
1	P8310250	18.0 ~ 24.0	168.3	205.6	209.2	258.7	25.0	53.1	1/8"
1.5	P8315250	22.0 ~ 24.0	168.3	205.6	209.2	258.7	25.0	53.1	1/8"
2	P8320320	25.0 ~ 35.0	187.3	230.2	233.8	288.1	32.0	57.9	1/4"
2.5	P8325320	30.0 ~ 35.0	187.3	230.2	233.8	288.1	32.0	57.9	1/4"
3	P8330400	36.0 ~ 47.0	209.6	261.9	266.7	332.0	40.0	70.1	1/4"
4	P8340400	48.0 ~ 65.0	231.8	281.0	285.8	351.1	40.0	70.1	1/4"



**DRILL HOLDERS**

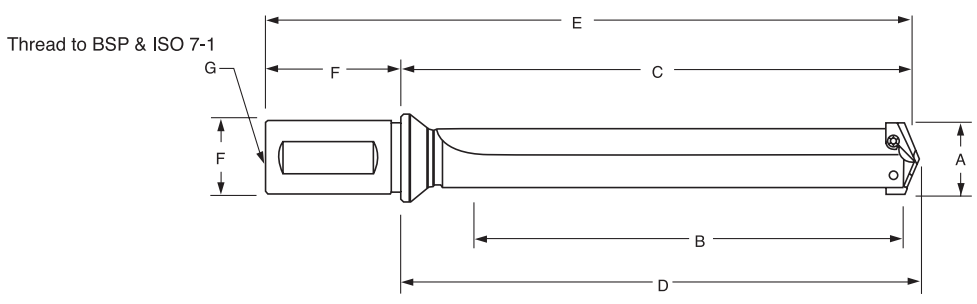
**FLANGED STRAIGHT SHANK HOLDERS EXTENDED LENGTH - SPIRAL FLUTE (METRIC)**  
 加长凸缘直柄刀杆-螺旋刃



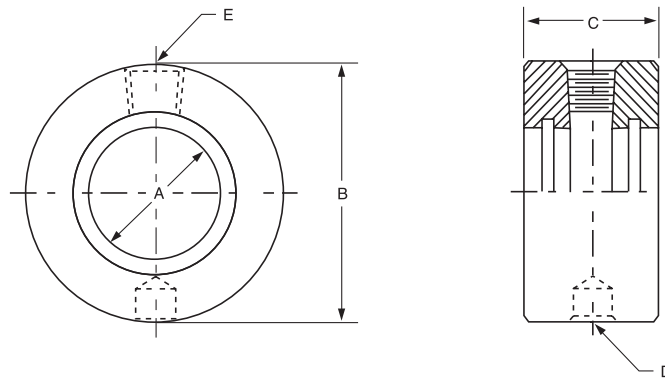
Series	EDP No.	A Drill Insert Range	B Max. Drill Depth	C Flute Length	D Ref. Length	E Overall Length	F Shank		G Pipe Tap
							Dia.	Length	
Y	P84Y0200	9.5 ~ 11.0	111.1	140.5	142.9	182.4	20.0	41.9	1/8"
Z	P84Z0200	11.5 ~ 12.5	111.1	140.5	142.9	182.4	20.0	41.9	1/8"
0	P8400200	13.0 ~ 17.5	114.3	142.9	145.7	184.8	20.0	41.9	1/8"
0.5	P8405200	15.5 ~ 17.5	114.3	142.9	145.7	184.8	20.0	41.9	1/8"
1	P8410250	18.0 ~ 24.0	269.9	307.2	310.8	360.3	25.0	53.1	1/8"
1.5	P8415250	22.0 ~ 24.0	269.9	307.2	310.8	360.3	25.0	53.1	1/8"
2	P8420320	25.0 ~ 35.0	288.9	331.8	335.4	389.7	32.0	57.9	1/4"
2.5	P8425320	30.0 ~ 35.0	288.9	331.8	335.4	389.7	32.0	57.9	1/4"

**DRILL HOLDERS**

**FLANGED STRAIGHT SHANK HOLDERS EXTENDED LENGTH - STRAIGHT FLUTE (METRIC)**  
 加长凸缘直柄刀杆-直刃



Series	EDP No.	A Drill Insert Range	B Max. Drill Depth	C Flute Length	D Ref. Length	E Overall Length	F Shank		G Pipe Tap
							Dia.	Length	
3	P7830400	36.0 ~ 47.0	349.3	401.6	406.4	471.7	40.0	70.1	1/4"
4	P7840400	48.0 ~ 65.0	422.3	471.5	476.3	541.6	40.0	70.1	1/4"



### Inch

Item No.	A	B	C	D	E	RCA Repair Kit Item No.	RCA O-Ring Replacements Item No.
	I.D.	O.D.	Length	Thread for Driving Rod	Pipe Tap		
PR110048	3/4"	1-3/4"	7/8"	5/16" -NC	1/8"	PR210048	PR310048
PR110100	1"	2-1/8"	1-1/8"	5/16" -NC	1/8"	PR210100	PR310100
PR110116	1-1/4"	2-1/2"	1-3/8"	3/8" -NC	1/4"	PR210116	PR310116
PR110148	1-3/4"	3"	1-3/8"	3/8" -NC	1/4"	PR210148	PR310148
PR110216	2-1/4"	3-3/4"	1-3/4"	1/2" -NC	1/2"	PR210216	PR310216

### Metric

Item No.	A	B	C	D	E	RCA Repair Kit Item No.	RCA O-Ring Replacements Item No.
	I.D.	O.D.	Length	Thread for Driving Rod	Pipe Tap		
PR120190	19.05	44.45	22.23	M8 X 1.25	◇1/8"	PR220190	PR320190
PR120254	25.40	53.97	28.57	M8 X 1.25	◇1/8"	PR220254	PR320254
PR120317	31.75	63.50	34.92	M10 X 1.5	◇1/4"	PR220317	PR320317
PR120444	44.45	76.20	34.92	M10 X 1.5	◇1/4"	PR220444	PR320444
PR120571	57.15	95.27	44.45	M12 X 1.75	◇1/2"	PR220571	PR320571

◇ Thread to BSP & ISO 7-1

### Torx Screws

Holder Series	Item No.	TORX Hand Driver	Drill Range Used With	
			Inch	Metric
Y	J07Y0010	J05Y0070	3/8" ~ 27/64"	9.5 mm ~ 11.0 mm
Z	J07Z0110	J05Z0070	7/16" ~ 1/2"	11.5 mm ~ 12.5 mm
0	J0800210	J0500080	33/64" ~ 11/16"	13.0 mm ~ 17.5 mm
0.5	J0805310	J0505080	39/64" ~ 11/16"	15.5 mm ~ 17.5 mm
1	J0910410	J0510090	45/64" ~ 15/16"	18.0 mm ~ 24.0 mm
1.5	J0915510	J0515090	55/64" ~ 15/16"	22.0 mm ~ 24.0 mm
2	J1520610	J0520150	31/32" ~ 1-3/8"	25.0 mm ~ 35.0 mm
2.5	J1525710	J0525150	1-3/16" ~ 1-3/8"	30.0 mm ~ 35.0 mm
3,4	J2030810	J0530200	1-13/32" ~ 2-9/16"	36.0 mm ~ 65.0 mm
5 ~ 8	J2550910	J0550250	2-1/2" ~ 4-1/2"	64.0 mm ~ 114.0 mm

\*\* Note : Replacement screws sold in packages(10 screws per package)